

Work Order ID 105240

105240

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July-30-13 8:59:54 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rear Locker Extender

Start Date: 7/30/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/12/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2273

D350-604-041

H

B

F

0.00

0.00

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PTP D350-604-041
CHG005

SCRAP

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Item ID: D350-604-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rear Locker Extender
 Start Date: 7/30/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/12/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	PURCHASING	0.00							
110									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 20732								
	Description: D350-604-041 Rear locker extender.								
	Manufacture as per dwg D2273								
	Supplier: Carbon-by-Design								
	Certification of Conformity and process sheet from Carbon-by-Design is required.								
	EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.								
	MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.								
	DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM								

12130730

1436/120

710 →

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☒ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Operator ☐ Offset/Setup ☐ Process ☐ Supplier ☒ Training ☐ Transport ☐ Unapproved ☐	2023/09/19	110	41	Rear loader Frame Solve Composites was found to be over weak + crack.	S 15/01/27 Q2042	SCRAP + DESTROY. No Replen. Part arrived in. Sept. 19th, 2013. no need to contact Supplier.	S 15/01/27	S 15/01/27	S 15/01/27		

FAULT CATEGORY				
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☒ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge 	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☒ Other

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Start Date: 7/30/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/12/13 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC5- Inspect part completeness to step on W/O

0.00

130

0.00

QC

Memo

Quality Control

Check hole locations to template. DT 8824 Check process sheet and audit:

140

0.00

140

0.00

Small Fab

Memo

Small Fab

1- INSTALL DECALS AS PER DWG

150

QC5- Inspect part completeness to step on W/O

0.00

150

0.00

QC

Memo

Quality Control

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Item Name: Rear Locker Extender

Start Date: 7/30/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/12/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	Pick Kit	0.00							
155									
Packaging	Memo	0.00							
Packaging	***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***								
158	QC4- 100% Inspect kits for completeness	0.00							
158									
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-604-041								
	Location: _____								
	PPP Rev: _____								

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Setup Start

NS1

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Stop

NS2

Item Name: Rear Locker Extender

Start Date: 7/30/13 Start Qty: 1.00

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Required Date: 8/12/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

a 140526

D

Picklist Print

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Page 1

Work Order ID: 105240
 Parent Item: D350-604-041
 Parent Item Name: Rear Locker Extender

Start Date: 7/30/13 Required Date: 8/12/13
 Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R 12.02.07 AS PER ECN12-
 521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-5 Camlock Stud		Purchased	No			155	Each	100.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST396		100							
				125602		50							
				m126400		50							
2600-6 Camlock Stud		Purchased	No			155	Each	273.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST380		273							
				122973		38							
				123150		17							
				124704		5							
				m126400		213							
2600-LW Camlock Retaining Washer		Purchased	No			155	Each	284.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST396		284							
				121524		9							
				122317		68							
				123150		31							
				m126330		176							
D2268 Placard		Manufactured	No			140	Each	27.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST008		27							
				100369		12							
				104271		10							
				69592		2							
				78908		1							
				88883		2							

Picklist Print

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Work Order ID: 105240
Parent Item: D350-604-041
Parent Item Name: Rear Locker Extender

Start Date: 7/30/13

Required Date: 8/12/13

Start Qty: 1.00

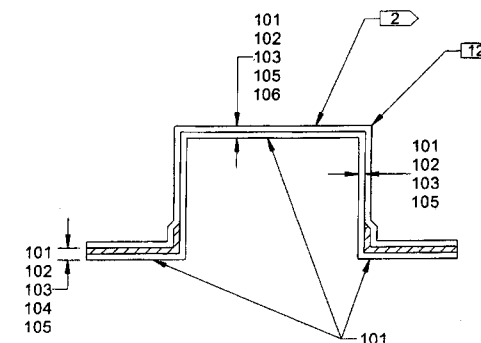
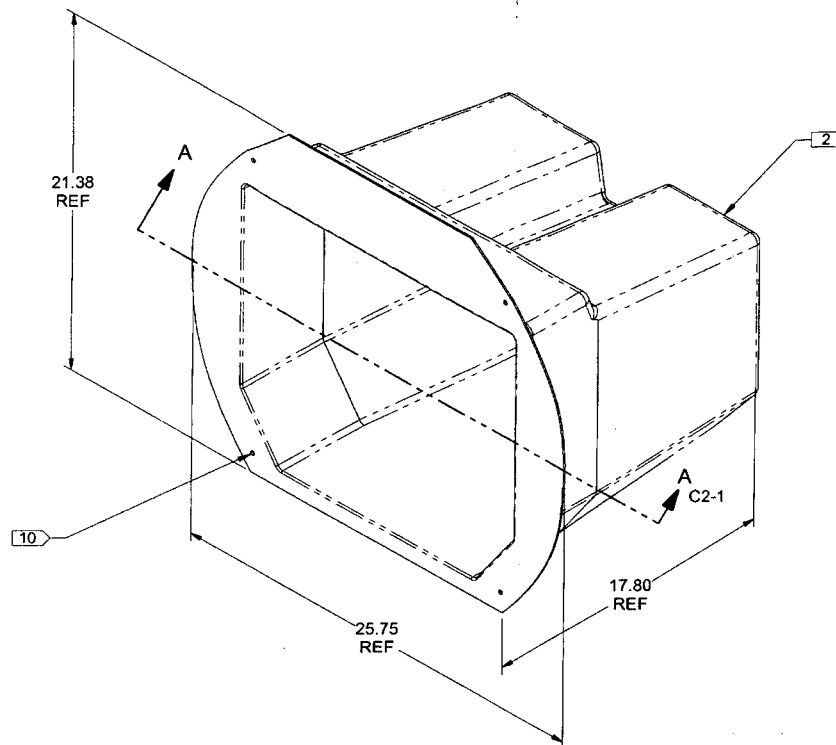
Required Qty: 1.00

D2269	Manufactured	No	140	Each	26.0000	1	1
Placard							
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
		ST008	26				
		100526	6				
		104393	10				
		88882	1				
		97606	9				
D2728-1	Manufactured	No	140	Each	-1.0000	0	0
Dart Logo label small							
D350-604-041P	Purchased	No	110	Each	4.0000	1	1
Rear Locker Extender							
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
		CA	4				
		103464	1				
		103465	1				
		103913	1				
		103914	1				

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Shop Packet Print

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SECTION A-A
C4-1

RELEASED
2012-03-29

NOTES:

1) MATERIALS:

RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9 oz = 9.7 oz 7781 WEAVE "S" GLASS
18 oz = 18.0 oz ROVING "E" GLASS

2) FINISH: FINISH THIS SURFACE WITH DUPONT GREY PRIMER LE 3404-S/L E 1175-S Δ

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 7.75 lbs

8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.

9) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM

10) TRIM & DRILL PER DT8020. OPEN HOLES TO Ø0.257 (4 PLACES)

11) CONSTRUCTION:

101-WHITE GLOSS GELCOAT # GEL 2330PAWK745 TO MIN THICKNESS OF 0.020

102-9 oz ALL OVER

103-18 oz ALL OVER

104-18 oz REINFORCE FRONT FLANGE EXTENDING 2" ON SIDES

105-9 oz ALL OVER

106-PEEL PLY

12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

D2273 REAR LOCKER EXTENDER

F	PRIMER LE 3404-S/L E 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST. ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. F
MFG. APPR.	DC	D2273	SHEET 1 OF 1
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	350 REAR LOCKER EXTENDER NTS	
DATE	12.02.27	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

BFG International USA, LLC

29 Distribution Way

Suite 101

Plattsburgh, NY 12901

Phone: 518-324-3838

Fax: 518-324-5530

Packing List**Bill** Dart Aerospace**To:** 1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

Canada

Ship Dart Aerospace**To:** 1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

Canada

Shipment No: 15252**Shipment Date:** 09/18/13**Ship Via:** Fedex Freight Collect**Order Number:** 12744**Order Date:** 07/30/13**Customer Code:** DART**Phone:** (613) 632-9577**PO Number:** 20732**Terms:** Net 30 Days

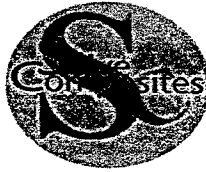
<u>Item</u>	<u>Quantity</u>				<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
	<u>Open</u>	<u>Shipped</u>	<u>Back Ord</u>	<u>Canceled</u>				
2	1	1	0		EA	D350-604-041P D350-604-041P Rear Locker Extender SN# B105240	F	12744-02
3	1	1	0		EA	D350-604-041P D350-604-041P Rear Locker Extender SN# B105239	F	12744-03

Packing Clerk's Initials

BFG International USA, LLC

Received In Good Order By

Dart Aerospace



Certificate of Conformance

Solve Composites

29 Distribution Way

Plattsburgh, New York, 12901

USA

Dart Aerospace Order Number: 20732

Part Number: D2273

Quantity: 2

Drawing Number: D2273, DT8020

Serial Number (s): B105239, B105240

Date: September, 18, 2013

Non-Conformances: None

This is to certify that the parts identified above conform to all applicable drawings and/or specifications as evidenced by reports on file, and that all other purchase order and quality requirements have been met.

Jerry Reyell

Engineering Manager

Solve Composites